

**Garant**
**Solid carbide short stepped drill 180°, TiAlN, for screws: M10**

**Order data**

Order number	125120 M10
GTIN	4045197065063
Item class	11E

**Description**
**Version:**

**Very sturdy**– step length to DIN 8376. **Tight concentricity tolerances** between drill and counterbore  $\varnothing$  guarantee exact alignment.

**Application:**

For screw through holes to DIN-ISO 273 and counterbores to DIN 74, sheet 2 form H, J, and K, medium version. For screws to DIN 912, 6912, and 7984, ISO 1207 (DIN 84).

**Technical description**

$\varnothing D_2$ 2nd step 180° h8	18 mm
Number of cutting edges Z	2
Feed f in steel < 1100 N/mm <sup>2</sup>	0.14 mm/rev.
Step height L <sub>1</sub> 1st step 180°	23 mm
Flute length L <sub>c</sub>	62 mm
for screws	M10
$\varnothing D_1$ 1st step 180° h8	11 mm
Shank $\varnothing D_s$	18 mm
Overall length L	123 mm
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 8376

Type	N
Tolerance nominal $\varnothing$	h8
Point angle	140 degrees
Shank	Plain shank
Countersink angle	180 degrees
Through-coolant	no
Shank tolerance	h6
Colour ring	without
Type of product	Stepped drill

### User data

	Suitability	$V_c$	ISO code
Alu plastics	suitable only under restricted conditions	260 m/min	N
Aluminium (short chipping)	suitable	180 m/min	N
Alu > 10% Si	suitable	180 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	60 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	35 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	35 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	30 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	25 m/min	S
GG(G)	suitable only under restricted conditions	110 m/min	K
CuZn	suitable	180 m/min	N
Uni	suitable		
wet maximum	suitable		

dry

suitable only under  
restricted conditions